



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBEA62309
Job Sheet 191516



008748

Part No: RBEA62309

Job Qty: 1 pcs

Part Name: AS350/355 Field Maintenance



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/4/19

Job Tracking No:

Due Date: 4/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEA62309 rev.S IPP REV:A 17.12.13 NEW ISSUE DD VERF:DP/IPP Rev.B 19.02.28 drawing revision
DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	4/18/19		0.00	0.07	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
105	Small Fab - 2 - B4B	1 pcs	4/18/19		0.00	1.00	Small Fab - 1 - B4B		MLC
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 5	1 pcs	4/18/19		0.00	0.00	QC 5 - 10		DAG 19 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		



Container No: S164002



Part: RBEA62309

Job No: 191516

Serial No/Batch: S164002

Revision: S

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 513 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/20/19

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				QC 5 - 30	
130	Packaging 3-1 - Stock - B4B	1 pcs	4/18/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - FG	1 pcs	4/18/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

DAS

21

9-89

MAR 20 2019

MAR 20 2019

DAS

21

9-89

Part Op 100 - Issue S/N.

Descriptions: 105 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1750-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per drawing.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1750-E	Pelican Case 1750	1 Ea (1 ea)	100-Small Fab - 1	5163509
2044T47 - ?N/A	Tube Ø1.09	1 ft (1 ea)	105-Small Fab - 2 - B4B	
2044T67 - ?N/A	Cap Ø1.09	2 Ea (2 ea)	105-Small Fab - 2 - B4B	
3896T31 - ?N/A	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	105-Small Fab - 2 - B4B	
5274T761	Polypropylene Vial for Flange Wrench Bolts	1 Ea (1 ea)	105-Small Fab - 2 - B4B	-5120466
7189K31	Cable Ties Black	1 Ea (1 ea)	105-Small Fab - 2 - B4B	-5032430
9052000	10" Mini Bungee Cord	4 Ea (4 ea)	105-Small Fab - 2 - B4B	5094608
9263K173 - ?N/A	O-Ring	1 Ea (1 ea)	105-Small Fab - 2 - B4B	
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	105-Small Fab - 2 - B4B	5145165
97526A421	Rivet	4 Ea (4 ea)	105-Small Fab - 2 - B4B	5147108
NAS1756-12	Remove Before Flight	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5134216
PAD210 - ?N/A	Foam Ø1 X 1	1 sf (1 ea)	105-Small Fab - 2 - B4B	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	105-Small Fab - 2 - B4B	-5021040
RBE-350DAMPER	Damper Spanner Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5109919
RBE-350HYD	Hydraulic Accumulator Fitting Gauge	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5162451
RBE-350INCLINOMETER	Inclinometer	1 Ea (1 ea)	105-Small Fab - 2 - B4B	6090828
RBE-350TDRS	Tail Rotor Driveshaft Bearing Run-Out Gauge	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5113045
RBE-350TEMP	Temperature Probe	1 pcs (1 ea)	105-Small Fab - 2 - B4B	-5098173
RBE350A93-3200-20-1	Main Gear Box/Rotor Brake Retaining Nut Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	-5115438
RBE350A93-3205-00E	Engine Gear Box Input Flange Holding Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5096000
RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5096015
RBE350A93-3300-20	Tail Rotor Hub Socket	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5117389
RBE350A93-3302-02	Tail Rotor Hub Lock Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5152598
RBE350A93-3303-02	Tail Rotor Head Body Extractor Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	-5156784
RBE350A93-3305-20-1	Tail Gearbox Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5120021
RBE350A93-3307-00	Tail Gearbox Seal Extractor	1 pcs (1 ea)	105-Small Fab - 2 - B4B	-5121650
RBE350A93-3312-03	Tail Rotor Hub Bushing Replacement Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5121701
RBE350A93-3316-20-1	Rotating Star Replacement Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5107535
RBE350A93-3317-20	Tail Rotor Hub Insert Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5146752
RBE350A93-3400-00	Drive Shaft Thimble	1 pcs (1 ea)	105-Small Fab - 2 - B4B	-5115892
RBE350A93-3500-00	Bearing Extractor	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5156433
RBE350A93-3501-20	Extraction Tool, Hydraulic Pump Pulley Bearing	1 pcs (1 ea)	105-Small Fab - 2 - B4B	-5122688
RBE350A94-2704-00	Pedals Locking Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5116132
RBE350A94-2706-00	Rigging Pin Set	1 pcs (1 ea)	105-Small Fab - 2 - B4B	-5121871
RBE350A94-2708-01	Tail Rotor Blade Locking Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5159538
RBE350A94-3301-00	Tail Rotor Accelerator Support	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5113371
RBE350A94-3700-A	Swashplate Immobilizing Tools Long Brace & Parts	1 pcs (1 ea)	105-Small Fab - 2 - B4B	-5157801
RBE350A94-3700-B	Swashplate Immobilizing Tools Adjustable Brace	1 pcs (1 ea)	105-Small Fab - 2 - B4B	
RBE350A94-3700-C	Swashplate Immobilizing Tools Adjustable Brace	1 pcs (1 ea)	105-Small Fab - 2 - B4B	-5131650
RBE350A94-3701-00	Main Rotor Rigging Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5155061
RBE350A94-5201-20	Cartridge, Dummy, Fuel	1 pcs (1 ea)	105-Small Fab - 2 - B4B	-5117125
RBE703A94-1130-01	Main Rotor Blade Trim Tab Tools Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5144801
RBE703A95-0505-00-15	TGB Drain Tube Quill Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	-5157581
RBE703A95-0508-00-15	MGB Drain Tube Quill Assembly	1 (1 ea)	105-Small Fab - 2 - B4B	-5158038
RBE703A95-0508-00-17	MGB Drain Tube Hose Assembly	1 (1 ea)	105-Small Fab - 2 - B4B	5158038-2
RBE703A95-0520-01-17	Engine & Hydraulic Drain Tube Quill Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5155725
RBE703A95-0520-01-19	Engine & Hydraulic Drain Tube Hose Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5161597
RBEA62309-2	Bottom Cushion use in case APP-1750-E	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5163512
RBEA62309-3	Stiffener Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5158538
RBEA62309-6	Top Cushion use in case APP-1750-E	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5163511
RBEA62309-7	Top Foam Cushion use in case APP-1750-E	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5163510
RBEA62309-8	Top Shelf Placard	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5159441
RBEA62309-9	Bottom Shelf Placard	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5159441
RBEA62310	AS350/355 Engine Strut	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5131300
RBT18025-13	Linear Scale (50 lbs)	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5141239
RBW109-3101-58-1-1	Hammer, Steel	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5145823
RBW109-3101-58-2-1	Hammer, Aluminum	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5158551

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	APP-1750-E	1	0	0
105-Small Fab - 2 - B4B	2044T47	1	60	0
	2044T67	2	199	0
	3896T31	2	578	0
	5274T761	1	28	0
	7189K31	1	772	0
	9052000	4	87	0
	9263K173	1	28	0
	97524A032	4	414	0
	97526A421	4	100	0
	NAS1756-12	1	396	0
	PAD210	1	3	0
	RB41011	1	397	0
	RBE-350DAMPER	1	13	0
	RBE-350HYD	1	9	0
	RBE-350INCLINOMETER	1	14	0
	RBE-350TDRS	1	23	0
	RBE-350TEMP	1	10	0
	RBE350A93-3200-20-1	1	20	0
	RBE350A93-3205-00E	1	6	0
	RBE350A93-3205-00T	1	7	0
	RBE350A93-3300-20	1	7	0
	RBE350A93-3302-02	1	5	0
	RBE350A93-3303-02	1	6	0
	RBE350A93-3305-20-1	1	14	0
	RBE350A93-3307-00	1	6	0
	RBE350A93-3312-03	1	10	0
	RBE350A93-3316-20-1	1	8	0
	RBE350A93-3317-20	1	10	0
	RBE350A93-3400-00	1	46	0
	RBE350A93-3500-00	1	10	0
	RBE350A93-3501-20	1	17	0
	RBE350A94-2704-00	1	11	0
	RBE350A94-2706-00	1	10	0
	RBE350A94-2708-01	1	3	0
	RBE350A94-3301-00	1	13	0
	RBE350A94-3700-A	1	10	0
	RBE350A94-3700-C	2	3	0
	RBE350A94-3701-00	1	6	0
	RBE350A94-5201-20	1	11	0
	RBE703A94-1130-01	1	5	0
	RBE703A95-0505-00-15	1	0	0
	RBE703A95-0508-00-15	1	0	0
	RBE703A95-0508-00-17	1	0	0
	RBE703A95-0520-01-17	1	0	0
	RBE703A95-0520-01-19	1	0	0
	RBEA62309-2	1	12	0
	RBEA62309-3	1	0	0
	RBEA62309-6	1	12	0
	RBEA62309-7	1	0	0
	RBEA62309-8	1	16	0
	RBEA62309-9	1	0	0
	RBEA62310	1	3	0
	RBT18025-13	1	21	0
	RBW109-3101-58-1-1	1	7	0
	RBW109-3101-58-2-1	1	12	0

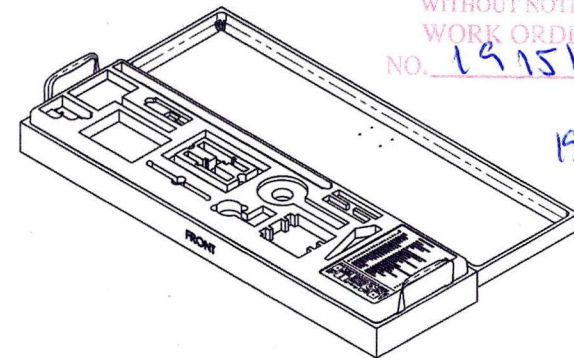
Part Specifications

Specifications could not be found.

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191516
ML5
19-0304

**RBEA62309 AS350/355 FIELD MAINTENANCE KIT**

SEE PREVIOUS REVISIONS FOR MORE INFORMATION

ITEM -10 WAS ITEM -9
ITEM -11 WAS ITEM -10
ITEM -12 WAS ITEM -11
ITEM -13 WAS ITEM -12

UPDATED BOM TO REFERENCE CORRECT TOOL NUMBERS TO BE INCLUDED IN KIT

-5 ADDED HEAT CUT NOTE

-8 ENGRAVING FOR BOTTOM SHELF REMOVED. UPDATED ENGRAVING

-9 IS BOTTOM SHELF PLACARD.

-10 P/N WAS McMaster#8835T93 (ELASTIC TIE DOWN) OR EQUIV. IS HIGHLAND#9052000 (ELASTIC TIE DOWN) OR EQUIV.

19-600 KPT

REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBEA62309 TITLE AS350/355 FIELD MAINTENANCE KIT COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	KPT		
CHECKED	KPT		
MFG. APPR.	DP		
APPROVED	WJP		
DATE 2/27/2019		REV. S SHEET 1 OF 12 SCALE NTS	

ITEM #	QTY	PART #	PART TITLE
-1	1	RBEA62309-1	PACKAGING ASSEMBLY
-8	1	RBEA62309-8	TOP SHELF PLACARD
-9	1	RBEA62309-9	BOTTOM SHELF PLACARD
-10	4	RBEA62309-10	HIGHLAND#9052000 OR EQUIV. (BUNGEE CORD 1/4" DIA. X 10" LG.)
-11	1	RBEA62309-11	NAS 1756-12 (REMOVE BEFORE FLIGHT FLAG)
-12	1	RBEA62309-12	McMaster#7189K31 OR EQUIV. (NYLON CABLE TIES 5-1/2" LG. X 1-1/8" MAX. BUNDLE DIA.)
-13	1	RBEA62309-13	McMaster#5274T761 OR EQUIV. (PLASTIC VIAL 2" DIA. X 1-5/8" HT.)
14	1	RBE350A93-3200-20	MGB/ROTOR BRAKE RETAINING NUT WRENCH
15	1	RBE350A93-3205-00E	ENGINE G/B INPUT FLANGE HOLDING WRENCH
16	1	RBE350A93-3205-00T	T/R G/B INPUT FLANGE HOLDING WRENCH
17	1	RBE350A93-3300-20	T/R HUB SOCKET
18	1	RBE350A93-3302-02	T/R HUB LOCK WRENCH
19	1	RBE350A93-3303-02	T/R BODY EXTRACTOR TOOL
20	1	RBE350A93-3305-20	TAIL GEARBOX WRENCH
21	1	RBE350A93-3307-00	TAIL GEARBOX SEAL EXTRACTOR
22	1	RBE350A93-3312-03	T/R HUB BUSHING REPLACEMENT TOOL
23	1	RBE350A93-3316-20	ROTATING STAR REPLACEMENT WRENCH
24	1	RBE350A93-3317-20	TAIL ROTOR HUB INSERT TOOL
25	1	RBE350A93-3400-00	DRIVE SHAFT THIMBLE
26	1	RBE350A93-3500-00	BEARING EXTRACTOR
27	1	RBE350A93-3501-20	EXTRACTION TOOL HYD. PUMP PULLEY BEARING
28	1	RBE350A94-2704-00	JAMMING TOOL, PEDALS
29	1	RBE350A94-2706-00	RIGGING PIN SET
30	1	RBE350A94-2708-01	T/R BLADE LOCK FIXTURE
31	1	RBE350A94-3301-00	T/R ACCELERATOR SUPPORT
32	1	RBE350A94-3700-A	SWASHPLATE IMMOBILIZING TOOL LONG BRACE
33	1	RBE350A94-3700-B	SWASHPLATE IMMOBILIZING TOOL SHORT BRACE
34	1	RBE350A94-3700-C	SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE
35	1	RBE350A94-3701-00	M/R RIGGING TOOL
36	1	RBE350A94-5201-20	CARTRIDGE, DUMMY, FUEL
37	1	RBE-350DAMPER	DAMPER SPANNER WRENCH
38	1	RBE-350HYD	HYDRAULIC ACCUMULATOR FITTING GAUGE
39	1	RBE-350INCLINOMETER	INCLINOMETER
40	1	RBE-350TEMP	TEMPERATURE PROBE
41	1	RBE-350TRDS	T/R DRIVESHAFT BEARINGS RUN OUT GAUGE
42	1	RBE703A94-1130-01-01	IMMOBILIZING CLIP ASSEMBLY
43	1	RBE703A94-1130-01-23	DEFLECTION CLIP ASSEMBLY
44	1	RBE703A95-0505-00-15	TGB DRAIN TUBE QUILL ASSEMBLY
45	1	RBE703A95-0508-00-15	MGB DRAIN TUBE QUILL ASSEMBLY
46	1	RBE703A95-0508-00-17	MGB DRAIN TUBE HOSE ASSEMBLY
47	1	RBE703A95-0520-01-17	ENGINE & HYDRAULIC DRAIN TUBE QUILL ASSEMBLY
48	1	RBE703A95-0520-01-19	ENGINE & HYDRAULIC DRAIN TUBE HOSE ASSEMBLY
49	1	RBEA62310	AS350/355 ENGINE STRUT
50	1	RBT18025-13	LINEAR SCALE
51	1	RBW109-3101-58-1-1	HAMMER, STEEL
52	1	RBW109-3101-58-2-1	HAMMER, ALUMINUM
53	1	RB41011	DART PLACARD
54	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :		Sequence #:		QTY Affected :		MRB (QS1042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details:							